

Work Order ID 131289

Thursday, April 02, 2015 10:18:24 AM

131289

Page 1

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Rotor Pedal Lock
 Start Date: 4/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/3/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MS Date: 15-04-02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120 0.00
120 Small Fab
 Small Fab Memo 0.00
 Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
 4- Assemble lock mechanism and cam and install decal as per Dwg D3371.
 Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>1125715</u>

1 FF APR 02 2015

130 0.00
130 Small Fab
 Small Fab Memo 0.00
 Small Fab Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

1 FF APR 02 2015

Work Order ID 131289

Thursday, April 02, 2015 10:18:24 AM

131289

Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	Small Fab					1	FF	APR 02 2015	
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							DAS 32 APR 02 2015
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							DAS 27 9-30 APR 02 2015
Packaging	PPP B1287								

Work Order ID 131289***131289***

Page 3

Thursday, April 02, 2015 10:18:24 AM

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Required Date: 4/3/2015 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15-47 / MW

15-4-2

Picklist Print

Thursday, April 02, 2015 10:18:28 AM

Page 1/3

Work Order ID: 131289

131289

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/2/2015

Required Date: 4/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			120	Each	16.0000	2	2			

X ***238-028***
3/16" Dowel Pin .5" long

**

FF

APR 02 2015

Location	Loc Qty	Loc Code
ST568	16	
106673	16	
108114		

AN526C832R6

Purchased No

120 Each 88.0000 4 4

AN526C832R6

Screw

**

FF

APR 02 2015

Location	Loc Qty	Loc Code
GA	88	
m131379	88	

D2728-7

Manufactured No

120 Each 0.0000 0 0

D2728-7

Dart Logo Label

**

FF

APR 02 2015

D3371-1

Manufactured No

120 Each 6.0000 1 1

D3371-1

Pedal Lock Base

**

FF

APR 02 2015

Location	Loc Qty	Loc Code
ST498	6	
106255	2	
109067	2	
70040	2	

1

Picklist Print

Thursday, April 02, 2015 10:18:28 AM

Page 2

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131289

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/2/2015

Required Date: 4/3/2015

Start Qty: 1.00

Required Qty: 1.00

D3371-3 Manufactured No

120 Each 10.0000 1 1

D3371-3

Pedal Lock Cover

**

FF

APR 02 2015

Location

Loc Qty

Loc Code

ST498

10

104353

10

D3373-7 Manufactured No

120 Each 15.0000 1 1

D3373-7

Cam Lock

**

FF

APR 02 2015

Location

Loc Qty

Loc Code

ST036

15

123528

4

94791

11

D3385-3 Manufactured No

120 Each 34.0000 1 1

D3385-3

Hinge

**

FF

APR 02 2015

Location

Loc Qty

Loc Code

ST036

34

117534

34

CBL-1240 Purchased No

130 f 193.1606 1.6666 2

CBL-1240

Cable

**

FF

APR 02 2015

Location

Loc Qty

Loc Code

GA

193.1606

m130006

193.1606

2

Picklist Print

Thursday, April 02, 2015 10:18:28 AM

Page 3

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131289

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 4/2/2015

Required Date: 4/3/2015

Start Qty: 1.00

Required Qty: 1.00

CBL-460	Purchased	No	130	Each	494.0000	2	2	
CBI -460								
Loop Sleeve								
						**		FF APR 02 2015

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D3384-1	Manufactured	No	GA	494				
			m131619	494			2	
D3384-1								
Cyclic Sock						**		FF APR 02 2015

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
HX-81	Purchased	No	ST500	6				
			123313	6			1	
HX-81								
1/4"-20 SHCS 3/8" long						**		FF APR 02 2015

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
NAS1149F0463P	Purchased	No	ST554	78				
			123436	78			1	
NAS1149F0463P								
Washer						**		FF APR 02 2015

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST260a	986	
	m127832	986	
	st268	323	
	m127832	315	
	m130388	8	

Thursday, April 02, 2015 10:18:28 AM

Shop Packet Print

Page 3